

Date: Wednesday, 15/08/2007 4:02:41 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33954
Estimate Number : 12455
P.C. Number : N/A
This Issue : 15/08/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 29291

Drawing Name : AFT MAINTENACE STEP

Part Number : D350591133
Drawing Number : D2946 REV B
Project Number : N/A
Drawing Revision : REV. B
Material : N/A
Due Date : 12/09/2007

Qty: 4 Um: Each

Written By :
Checked & Approved By :
Comment : Est Rev.B 05.10.14 Modified step 10 KJ/EC
Est Rev.B 06.07.19 D2946 @ rev.b EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-133 CHG002

Er 21/09/21

2.0 D2622120C



Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

.500 D2622-120C

Extrusion

B32858

a.m

07.09.04

4

3.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

a.m

07.09.04

4

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

Er 07.09.11 4

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 21/09/21

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Plate 333861

SE 07.09.11

4

6.0

D2944

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2944

Support 34004

SE 07.09.11

4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Debur and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/R Aluminum Rod M103794
M104721

3-Grind End Cap welds flush

Q.M 07.09.13

SE 07.09.11

SE 07.09.11

4

4

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/07/09/13 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q.M 07/09/13

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07.09.13

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


















QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT MAINTENACE STEP	
Job Number: 33954		Part Number: D350591133	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			(4X) 07/09/17
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION M-L			
12.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1			
Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.			
A/R AL ROD BATCH: M103794 Q-M 07.09.2004 07-09-18 4			
13.0	QC9	VISUAL WELDING INSPECTION	
			
Comment: VISUAL WELDING INSPECTION PD 07-09-20 (4)			
14.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP E 07/09/20 (4)			
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Touch Up Chemical conversion BR 07-09-20 (4)			
16.0	POWDER COATING	POWDER COATING	
			(4X)
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M-L 07/09/20			
17.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D2946 and QSI 005 4.4 M105386 07-09-20 (4)			
18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: Inspect Powder Coat and Wing Walk 07/09/20 (4)			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

20.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
Mounting Lug
Batch: B32163 -

21.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
Mounting Lug
Batch: B30993 -

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2606 f(s)/Unit Total: 5.0425 f(s)
Abrasion Strip 7.20" long x2
Batch: B25656

23.0

D2945

Step Mounting Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Step Mounting Plate
Batch: B29914 -

24.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Bolt
Batch: M102140 -

25.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
Bolt
Batch: M102280 -

EP 07/09/21 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 07/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 33954

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN414A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Batch: M102473

27.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Washer

Batch: M104746

28.0

MS21042L4

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Nut

Batch: M104248

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location:

PPP Rev: D

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-09-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: 2-11

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 2-11						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



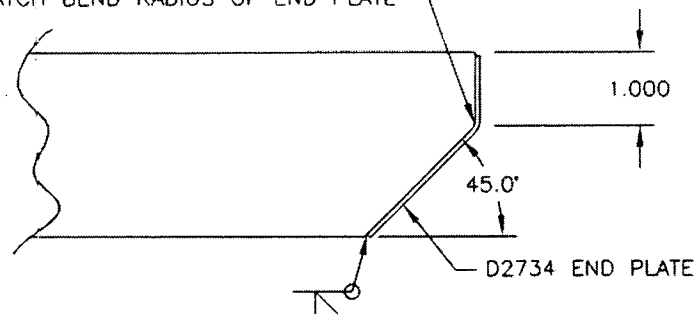
D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

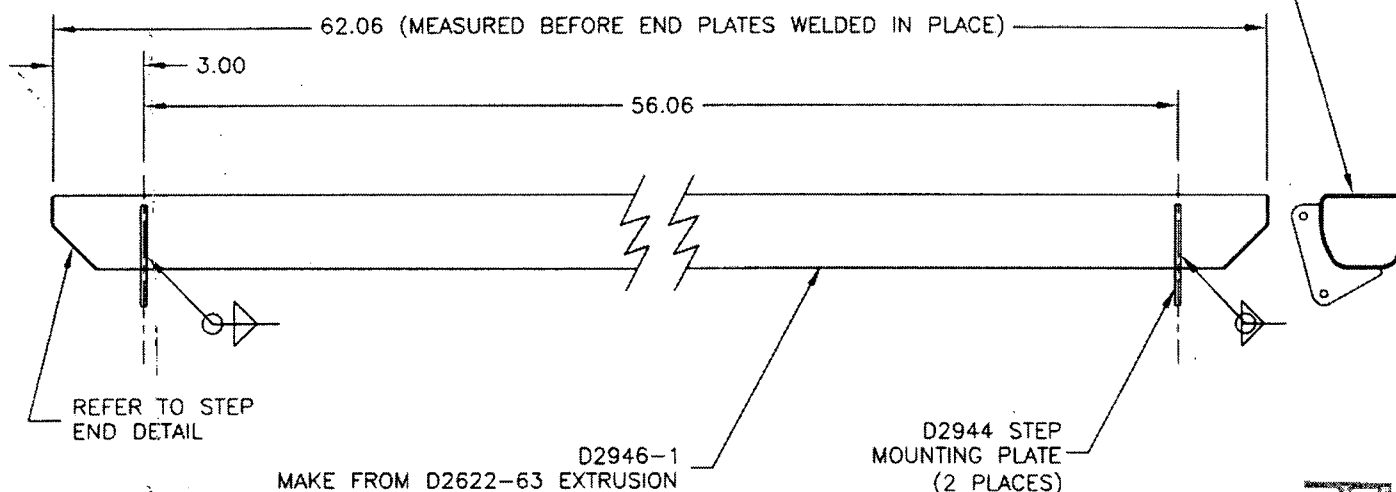
NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	#	APPROVED	#	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	DRAWING NO.	D2946	REV. B
TITLE	STEP ASSEMBLY	SCALE	1:6	SHEET 1 OF 1
REV. A	99.12.13	NEW ISSUE		
REV. B	05.11.14	UPDATE FINISHING NOTE		

RELEASED
05.11.28

